

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000122**Date Inspected:** 02-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:

Index Lot #: B71-001-07a**Witness Lot #:** B60-011-07**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Jiang Xian Hu**ID #:** N/A**Joint Description:** B-U2a-GF

N/A

WPS ID #: PWS-B-T-2231-F-1

N/A

Base Metal: A-709-50F2

N/A

PQR ID #: HP200706

N/A

Thickness: 26 mm

N/A

Process: FCAW-G

N/A

Electrode Spec/Class: AWS-5.20/E71-T1

N/A

Positions: 1-G

N/A

Backing Material: A-709-50T2

N/A

CWI: Liu Liu

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: AWS 5.12.1

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

The Caltrans Quality Assurance Inspector (QA) reviewed Radiographic Testing (RT) film for the above procedure.

QA observed approximately 80mm of lack of fusion in the beginning of the weld joint. However, after review of the film, it was determined that this indication was in the "discard" area of the test plate. The film appears to comply with the contract requirements.

Summary of Conversations:

QA spoke with ZPMC Quality Control Engineer Lu Jian Hua regarding the lack of fusion indication observed.

Mr. Lu stated they would note the indication on the RT report and indicated that the weld was acceptable, as the indication is in the "discard" area of the test plate.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer